

Work Order ID 133376

Monday, June 08, 2015 3:59:17 PM

133376

Page 1

Item ID: D2932-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle RH Out, 206
 Start Date: 6/08/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/08/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: ML3 Date: JUN 09 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2932	Rev C

100	HAAS CNC VERTICAL MACHINING #1	0.01				4	Ø		DAS 40 9-89 15/08/13
-----	--------------------------------	------	--	--	--	---	---	--	-------------------------------

100
 HAAS 1
 HAAS CNC vertical machine #1

Memo
 Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110	CONVENTIONAL MILLING MACHINE	0.00				4	Ø		DAS 40 9-89 15/08/13
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110
 Mill Conv
 Conventional Milling Machine

Memo
 Machine Keyway and inspect per attached dimension sheet

120	QC1- Inspection performed by CMM	0.00				4	Ø		DAS 14 9-89 15/08/18
-----	----------------------------------	------	--	--	--	---	---	--	-------------------------------

120
 QC
 Quality Control

Memo
 Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : ☐																					

Monday, June 08, 2015 3:59:17 PM

Page 2

2.30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
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Page 3

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Revision ID: Stop ***NS2***
Item Name: Saddle RH Out, 206
Start Date: 6/08/15 Start Qty: 4.00 ***4*** Cust Item ID:
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						(4)			
QC	Memo	0.00							
Quality Control									AUG 28 2015
170	Identify as per dwg & Stock Location: <u>st 396</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									AUG 31 2015
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01							
Quality Control									15/8/31

20150831

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause :		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, June 08, 2015 3:59:17 PM

Page 1

Work Order ID: 133376

133376

Parent Item: D2932-2

D2932-2

Parent Item Name: Saddle RH Out, 206

Start Date: 6/08/15

Required Date: 6/08/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	0.0000	1	4		DAS 37 9:59	15-07-07
D6101-003									**				
Saddle Billet, 7075													

MAT 46

B 132646

4.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD	Work Order: 133376
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

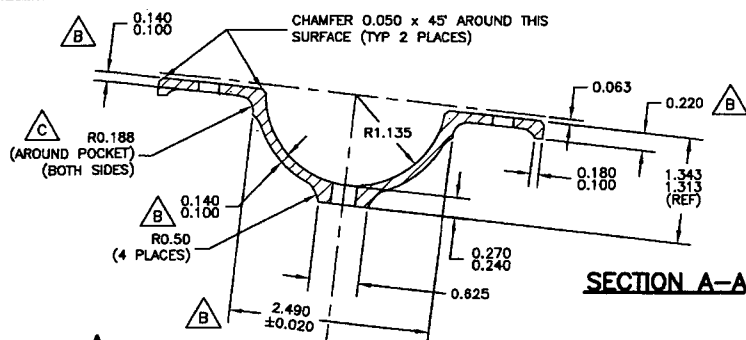
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.115	.115	.116	.115		
B	0.100	0.140		.112	.115	.116	.115		
C	0.100	0.140		.112	.115	.116	.115		
D	0.210	0.230		.226	.227	.223	.222		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.115	.122	.121	.120		
O	0.540	0.560		.548	.549	.548	.548		
P	0.490	0.510		.497	.497	.498	.499		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.253	.251	.251	.251		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.1352	1.1370	1.1370	1.1360		
Y	1.565	1.585		1.5749	1.5770	1.5767	1.5760		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

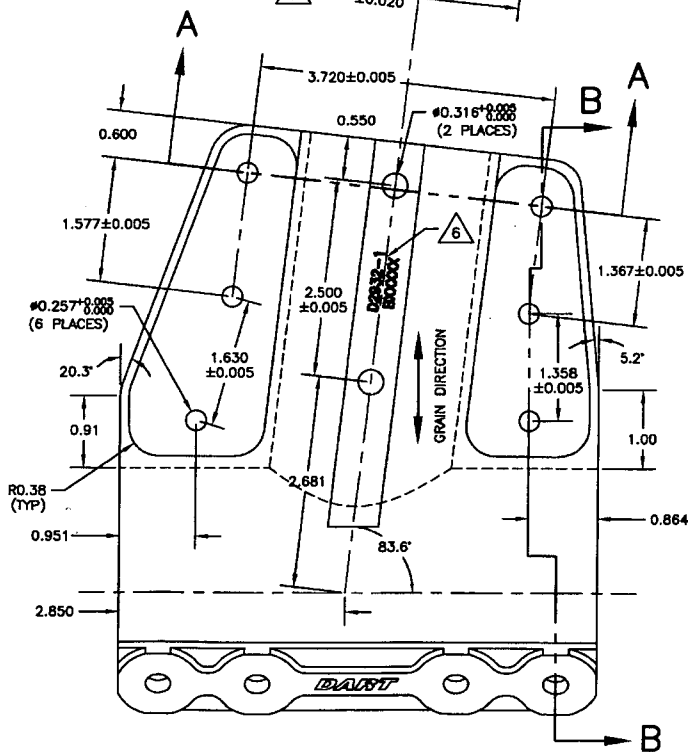
Measured by: <u>AS</u>	DAS	DAS
Date: <u>15/07/11</u>	08	40
	9-89	9-89

Audited by: <u>SL</u>
Date: <u>15-8-25</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION A-A

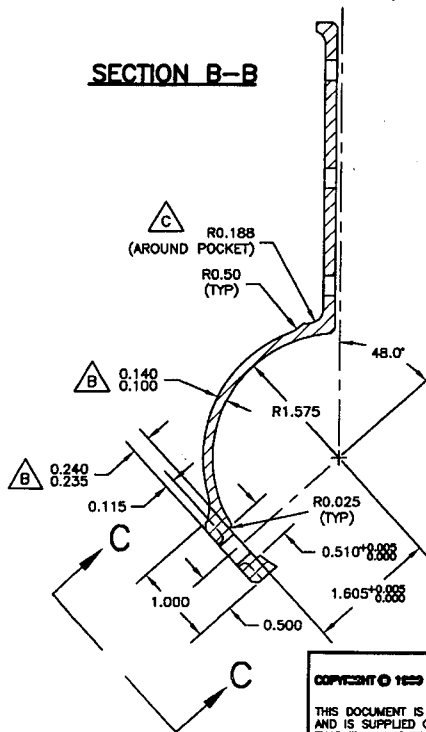


RELEASED

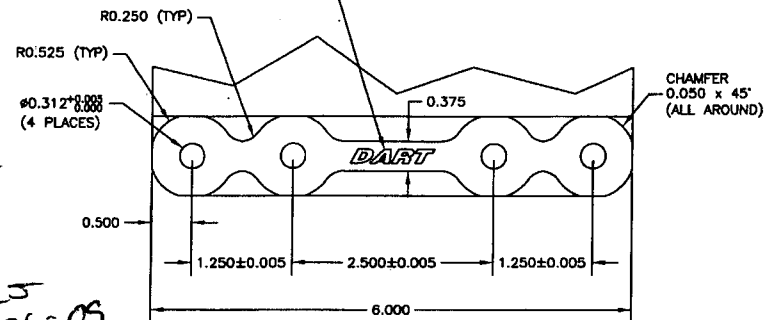
07-02-12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1323376 MLS
1506-09

SECTION B-B



ENGRAVE DART LOGO TO MAX DEPTH
OF 0.005 WITH MIN RAD 0.250



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D8101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	<i>4</i>	DRAWN BY <i>CB</i>
CHECKED	<i>PH</i>	APPROVED <i>4</i>
DATE	06.11.09	TITLE SADDLE OUTSIDE
COPYRIGHT © 1999 BY DART AEROSPACE USA, INC.		DART AEROSPACE USA, INC. BELLINGHAM, WA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		DRAWING NO. D2932 REV. C SHEET 1 OF 1 SCALE 2:3



Part Number: D2932-2	Rev: C	- Page 1 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2932	Work Order: 133376

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
1	0.120	+0.020/-0.020	0.116	0.124	0.123	0.122	
D2	0.050	+0.010/-0.010	0.045	0.042	0.045	0.043	
3	0.063	+0.010/-0.010	0.059	0.057	0.058	0.059	
4	0.220	+0.010/-0.010	0.227	0.225	0.225	0.224	
5	1.328	+0.015/-0.015	1.329	1.329	1.329	1.329	
D6	0.140	+0.040/-0.040	0.140	0.140	0.140	0.140	
D7	0.120	+0.020/-0.020	0.125	0.125	0.124	0.125	
D8	0.255	+0.015/-0.015	0.251	0.251	0.251	0.253	
D9	0.625	+0.010/-0.010	0.635	0.635	0.635	0.635	
D10	2.490	+0.020/-0.020	2.491	2.491	2.491	2.491	
D11	0.120	+0.020/-0.020	0.125	0.125	0.127	0.127	
D12	0.188	+0.010/-0.010	0.188	0.188	0.188	0.188	
13	0.3120	+0.0050/0.0000	0.3126	0.3127	0.3129	0.3128	
14	0.500	+0.010/-0.010	0.499	0.498	0.499	0.499	
15	1.250	+0.005/-0.005	1.250	1.250	1.249	1.249	
16	2.500	+0.005/-0.005	2.499	2.499	2.500	2.500	
17	1.250	+0.005/-0.005	1.250	1.249	1.249	1.250	
18	6.000	+0.010/-0.010	6.000	6.000	6.000	6.000	
D19	0.050	+0.010/-0.010	0.040	0.040	0.040	0.040	
20	0.063	+0.010/-0.010	0.065	0.064	0.064	0.065	
Ang21	48.000	+0.500/-0.500	47.713	47.795	47.784	47.751	
D22	0.510	+0.005/0.000	0.512	0.512	0.512	0.512	
23	1.605	+0.005/0.000	1.610	1.610	1.610	1.610	
24	0.500	+0.010/-0.010	0.504	0.505	0.505	0.506	
D25	1.000	+0.010/-0.010	1.005	1.005	1.005	1.005	
26	0.115	+0.010/-0.010	0.112	0.112	0.113	0.113	
D27	0.235	+0.005/0.000	0.238	0.238	0.238	0.238	
D28	0.120	+0.020/-0.020	0.115	0.115	0.116	0.117	
29	1.575	+0.010/-0.010	1.575	1.576	1.576	1.575	
30	3.720	+0.005/-0.005	3.717	3.719	3.720	3.719	
31	0.550	+0.010/-0.010	0.551	0.551	0.550	0.550	

Measured by:
Mathieu Lamarche

Date:
2015-8-18

Audited by:

Date:

SL
15-8-25



Part Number: D2932-2	Rev: C	- Page 2 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2932	Work Order: 133376

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
32	0.3160	+0.0050/0.0000	0.3160	0.3160	0.3160	0.3160	
33	1.367	+0.005/-0.005	1.367	1.367	1.368	1.368	
34	5.200	+0.500/-0.500	5.193	5.198	5.211	5.203	
35	1.358	+0.005/-0.005	1.359	1.359	1.359	1.359	
36	0.864	+0.010/-0.010	0.861	0.863	0.862	0.861	
37	83.600	+0.500/-0.500	83.562	83.564	83.570	83.565	
38	2.681	+0.010/-0.010	2.682	2.683	2.684	2.684	
39	2.850	+0.010/-0.010	2.851	2.851	2.851	2.851	
40	0.951	+0.010/-0.010	0.951	0.954	0.954	0.955	
41	20.300	+0.500/-0.500	20.269	20.264	20.271	20.273	
42	1.630	+0.005/-0.005	1.631	1.629	1.629	1.629	
43	0.2570	+0.0050/0.0000	0.2582	0.2580	0.2581	0.2581	
44	1.577	+0.005/-0.005	1.576	1.578	1.578	1.578	
45	0.600	+0.010/-0.010	0.601	0.599	0.598	0.598	
46	2.500	+0.005/-0.005	2.500	2.499	2.499	2.499	
47	1.135	+0.010/-0.010	1.133	1.133	1.133	1.133	

Measured by:
Mathieu Lamarche

Date:
2015-8-18

Audited by:

Date:

SL
15-8-25